



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
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Tel (613) 632-5200
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646.4001

Job Sheet 189565

Part No: 646.4001

Job Qty: 1 ea

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/28/19

Job Tracking No:

Due Date: 3/25/19

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/25/19	0.00	0.00	Start Up Stores/Pkg-1			MAR 01 2019
110	Packaging	1 pcs	3/25/19	0.00	0.00	Packaging1-1			MAR 13 2019
120	QC	1 pcs	3/25/19	0.00	0.00	QC4			MAR 13 2019
130	Packaging	1 pcs	3/25/19	0.00	0.00	Packaging3-1			MAR 13 2019
135	DC	1 pcs	3/25/19	0.00	0.00	DC			MAR 13 2019
140	QC21-FG	1 Ea	3/25/19	0.00	0.00	QC21			MAR 13 2019

Part Op **130** - Identify and pack for shipping as per PPP 646.4001 Location: _____
 Descriptions: **135** - Photocopy bluefile & type labels per PPP 646.4001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	90-Start up Operation	5019004
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5136925
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5136931
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	5133790
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	90-Start up Operation	5136734
646.2910	Deflector	1 pcs (1 ea)	90-Start up Operation	5093821
646.3001	Lower Cable Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5159178
646.3110	Channel	1 Ea (1 ea)	90-Start up Operation	5154342
646.3210	Support	1 Ea (1 ea)	90-Start up Operation	5131207
646.3301	Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5159082
646.3510	Strut	1 Ea (1 ea)	90-Start up Operation	5127740
646.3511	Strut	1 Ea (1 ea)	90-Start up Operation	5127662
646.3610	Filler	1 pcs (1 ea)	90-Start up Operation	5131480
646.3710	Doubler	1 pcs (1 ea)	90-Start up Operation	5059684
646.3711	Clip	1 pcs (1 ea)	90-Start up Operation	5063766
646.3712	Clip	1 pcs (1 ea)	90-Start up Operation	5128050
646.3713	Gusset	1 Ea (1 ea)	90-Start up Operation	5124418
646.3714	Gusset	1 pcs (1 ea)	90-Start up Operation	5038824
646.3715	Strut Doubler	2 pcs (2 ea)	90-Start up Operation	5139085
646.3716	Gauge Bracket	1 pcs (1 ea)	90-Start up Operation	5063782

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____			MRB (QSI042) ☐
Instructions: FAA STC SH02180LA 14/08/02-15 STC SH09- Exp Date: 08/10/2019 Inspector: _____ Revision: _____ Serial No/Batch: S162135 Job No: 189565 Part: 646.4001 Container No: S162135 DART AEROSPACE 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com					
Description Work Order Deviation					Completed By _____
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
Other/Details: _____					QC / QA Coordinator _____

646.3717	Doubler	1 pcs (1 ea)	90-Start up Operation	5082327
646.3718	Custom Washer	2 pcs (2 ea)	90-Start up Operation	5145123
646.3719	Doubler	2 pcs (2 ea)	90-Start up Operation	5145244
646.3810	Bracket	2 pcs (2 ea)	90-Start up Operation	5150081
646.3811	Radius Block	1 pcs (1 ea)	90-Start up Operation	5070843
646.3812	Gusset Bracket	2 Ea (2 ea)	90-Start up Operation	5150415
646.3813	AS350 Strut Bracket	1 pcs (1 ea)	90-Start up Operation	5131319
646.3910	Shim	4 pcs (4 ea)	90-Start up Operation	5128166
646.3911	Shim	1 pcs (1 ea)	90-Start up Operation	5133609
646.3912	Shim	4 pcs (4 ea)	90-Start up Operation	5124372
646.3913	Shim	1 pcs (1 ea)	90-Start up Operation	5041498
646.9410	Shim	1 pcs (1 ea)	90-Start up Operation	5056998
647.0112	Strut Bracket	2 pcs (2 ea)	90-Start up Operation	5133211
647.7703	Strut Assembly	2 pcs (2 ea)	90-Start up Operation	5145539
650.9201	Eyelet Bracket Assembly	2 Ea (2 ea)	90-Start up Operation	5131245
AN3-11A	Bolt	10 Ea (10 ea)	90-Start up Operation	5129968
AN3-12A	Bolt	2 Ea (2 ea)	90-Start up Operation	5095479
AN3-13A	Bolt	1 Ea (1 ea)	90-Start up Operation	5098032
AN3-3A	Bolt	4 Ea (4 ea)	90-Start up Operation	5131193
AN3-4A	Bolt	10 Ea (10 ea)	90-Start up Operation	5149178
AN3-5A	Bolt	2 Ea (2 ea)	90-Start up Operation	5149158
AN3-6A	Bolt	2 Ea (2 ea)	90-Start up Operation	5103950
AN316C4R	Nut, Jam	2 Ea (2 ea)	90-Start up Operation	5133132
AN44-5A	Eyebolt	2 Ea (2 ea)	90-Start up Operation	5131212
AN4C7A	Bolt	2 Ea (2 ea)	90-Start up Operation	5071343
AN665-34R	Clevis	2 Ea (2 ea)	90-Start up Operation	5142147
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea)	90-Start up Operation	5133189
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	90-Start up Operation	5136137
MS20426AD5-7	Rivet	2 Ea (2 ea)	90-Start up Operation	FM133922-36
MS20470AD5-5.5	Rivet	8 Ea (8 ea)	90-Start up Operation	FM134063
MS20470AD5-6	Rivet	8 Ea (8 ea)	90-Start up Operation	5048897
MS20470AD5-7	Rivet	3 Ea (3 ea)	90-Start up Operation	5123425
MS21042L08	Nut	2 Ea (2 ea)	90-Start up Operation	5080644
MS21042L3	Nut	63 Ea (63 ea)	90-Start up Operation	5130347
MS21042L4	Nut	2 Ea (2 ea)	90-Start up Operation	5149814
MS21047-3	Nut Plate	18 Ea (18 ea)	90-Start up Operation	5103943 X5 5152872 X13
MS24693-C278	Screw	5 Ea (5 ea)	90-Start up Operation	5065341
MS24694-S51	Screw	5 Ea (5 ea)	90-Start up Operation	5123459
MS24694-S54	Screw	2 Ea (2 ea)	90-Start up Operation	5152667
MS24694-S55	Screw	3 Ea (3 ea)	90-Start up Operation	5099526
MS27039-08-13	Screw	2 Ea (2 ea)	90-Start up Operation	5123937
MS27039-1-10	Screw	2 Ea (2 ea)	90-Start up Operation	5148165
MS27039-1-12	Screw	6 Ea (6 ea)	90-Start up Operation	5124664
MS27039-1-16	Screw	24 Ea (24 ea)	90-Start up Operation	5104364
MS27039-1-19	Screw	22 Ea (22 ea)	90-Start up Operation	5142052 X20 5155664 X2
MS27039-1-20	Screw	2 Ea (2 ea)	90-Start up Operation	5094554
MS27039-1-21	Screw	4 Ea (4 ea)	90-Start up Operation	5104011
NAS1149F0332P	Washer	144 Ea (144 ea)	90-Start up Operation	5157648
NAS1149F0363P	Washer	2 Ea (2 ea)	90-Start up Operation	5075330
NAS1149F0432P	Washer	4 Ea (4 ea)	90-Start up Operation	512652
NAS1149FN832P	Washer	4 Ea (4 ea)	90-Start up Operation	5143716

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.0129	8	96	0
	600.0990	1	20	0
	600.0991	1	20	0
	600.1012	1	20	0
	600.1013	5	101	0
	646.2910	1	8	0
	646.3001	1	4	0
	646.3110	1	5	0
	646.3210	1	10	0

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

646.3301	1	4	0
646.3510	1	6	0
646.3511	1	25	0
646.3610	1	21	0
646.3710	1	34	0
646.3711	1	21	0
646.3712	1	24	0
646.3713	1	28	0
646.3714	1	27	0
646.3715	2	25	0
646.3716	1	20	0
646.3717	1	26	0
646.3718	2	32	0
646.3719	2	24	0
646.3810	2	10	0
646.3811	1	10	0
646.3812	2	4	0
646.3813	1	17	0
646.3910	4	69	0
646.3911	1	25	0
646.3912	4	41	0
646.3913	1	20	0
646.9410	1	82	0
647.0112	2	54	0
647.7703	2	18	0
650.9201	2	49	0
AN3-11A	10	107	0
AN3-12A	2	134	0
AN3-13A	1	73	0
AN3-3A	4	309	0
AN3-4A	10	105	0
AN3-5A	2	102	0
AN3-6A	2	127	0
AN316C4R	2	48	0
AN44-5A	2	43	0
AN4C7A	2	107	0
AN665-34R	2	28	0
CCR264SS3-02	36	509	0
CR3213-5-3	14	215	0
MS20426AD5-7	2	939	0
MS20470AD5-5.5	8	117	0
MS20470AD5-6	8	894	0
MS20470AD5-7	3	97	0
MS21042L08	2	1,237	0
MS21042L3	63	1,976	0
MS21042L4	2	1,579	0
MS21047-3	18	243	0
MS24693-C278	5	61	0
MS24694-S51	5	247	0
MS24694-S54	2	32	0
MS24694-S55	3	200	0
MS27039-08-13	2	489	0
MS27039-1-10	2	157	0
MS27039-1-12	6	108	0
MS27039-1-16	24	376	0
MS27039-1-19	22	263	0
MS27039-1-20	2	106	0
MS27039-1-21	4	46	0
NAS1149F0332P	144	1,965	0
NAS1149F0363P	2	474	0
NAS1149F0432P	4	810	0
NAS1149FN832P	4	3,186	0

Part Specifications

Specifications could not be found.

Plex 1/28/19 1:11 PM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					